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RBW6522A00231-W142AJ-

3T-3

Job Sheet 199161



Part No: RBW6522A00231-W142AJ-3T-3 **Job Qty:** 1 pcs

Part Name: Base Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6522A00231-W142AJ-3T Rev 5 IPP Rev A 18.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1 pcs	10/7/19	10/7/19	0.00	0.10	Bandsaw - 1		SL 19-9-18
110	SL-2500Y - 2 - B4B	1 pcs	10/7/19	10/7/19	1.00	0.50	SL-2500Y - 1 - B4B		SL
120	QC 2	1 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 NV5000 - 1 - B4B	1 pcs	10/7/19	1.00 0.25	NV5000 - 1 - B4B	HA/SCC 19-09-19
				NV5000 - 2 - B4B	
140 QC 2	1 pcs	10/7/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	HA/SCC 19-09-19
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
150 QC 8	1 pcs	10/7/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	De 19-09-21
				QC 8 - 9	
				QC 8 - 68	

					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
180	Outsource - 4 - Anodize	1 pcs	10/7/19	0.00 0.00		
190	Packaging 2-1 - Receive - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
200	QC 6	1 pcs	10/7/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
210	Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
						</

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	1 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks to 1.42"

Descriptions: 110 - (MORI SL2500Y LATHE) 1-Machine as per folio FC551 FOLIO REV: AA DWG REV: 5 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC551 FOLIO REV: AA DWG REV: 5 2-Debur

140 - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

150 - (QC8- Inspect parts - second check)

180 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

190 - (Receive & Inspect for Damage & Mat'l Certs)

200 - (QC6- All purchased or subcontracted products)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R6.250	6061-T6 Round Bar 6.250"	.1200 ft (.12 ea)	100-Bandsaw - 1	<u>5048551: .72</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6R6.250	0	4	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework Scrap Use-as-is	Skid-tube Machining Large Fab	Cross tube Small Fab Finishing	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Part No. _____					
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing	
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish	
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread	
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up		
Human Factors	Other/Details: _____				

DART AEROSPACE LTD		Work Order:	199161
Description: Base plate		Part Number:	RBW6522A00231-W142A1-3T-3
Inspection Dwg: RBW6522A00231-W142A1-3T-3 Rev: 5		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.315	$\pm .005$	.316	✓		VERW 2.2	
2.520	$+0 - .0012$	2.5193	✓		go-no go	
.138	$\pm .005$	.140	✓		VERW	
2.362	$+0 - .0012$	2.3613	✓		go-no go	
1.575	$+0 - .001$	1.5743	✓		mic SCL-4	
.315	$\pm .005$	.313	✓		VERW	
.472	$\pm .005$	.473	✓		"	
4.409	$\pm .005$	4.409	✓		mic SB-06	
1.300	$\pm .005$	1.299	✓		VERW	
4.092	$+0 - .0014$	4.0914	✓		mic SB-06	
2.559	$\pm .0005$	2.561	✓	Caliper	SCL-08	
.794	$\pm .0005$	.795	✓			
M6x1	GH	O.K.	✓		GO NO-60	
Ø1.968 B.C.	$\pm .0005$	1.968	✓		Caliper	SCL-08
.795	$\pm .0005$	.795	✓			
0.08	$\pm .0010$	0.040	✓			
30°	$\pm .05°$	30°	✓		Angle Gauge	
.433	$\pm .005$	.434	✓		VERW	M6P-04
2.555	$\pm .010$	2.555	✓		Dial	
.472	$\pm .010$	.472	✓		"	
1.976	$\pm .010$	1.976	✓		"	
1.685	$\pm .010$	1.685	✓		"	
.425	$\pm .010$	.425	✓		"	
2.543	$\pm .010$	2.543	✓		"	
2.555	$\pm .010$	2.555	✓		"	
.472	$\pm .010$	.472	✓		"	
1.976	$\pm .010$	1.976	✓		"	
1.685	$\pm .010$	1.685	✓		"	

Measured by:	JL / JCL	Checked by:	B.	QC Inspector:	
Date:	19-9-10	Date:	19-09-21	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

